Dart Aerospace Ltd.

Date: Monday, 09/03/2009 1:45:53 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: STEP HI LONG
Job Number	: 46340		
Estimate Number	: 12897		
P.O. Number	:	**Part Number**	: D32721
This Issue	: 09/03/2009 **S.O. No.** :	**Drawing Number**	: D3272 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: B
Previous Run	: 46338	**Material**	:
Written By	:	**Due Date**	: 31/03/2009 **Qty:** 10 **Um:** Each
Checked & Approved By	: JVD 09.03.09		
Comment	: Est Rev:A New Issue 07-06-09 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Step Extrusion

*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2622-120	Extrusion	B45494

SAD 09-03-30 10

Seq. #:	Machine Or Operation:	Description :
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

SAD 09-03-30 10

Seq. #:	Machine Or Operation:	Description :
3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

S 09/03/31 (x10)

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA

SAD 09-03-31 (10)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:45:53 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP HI LONG

Job Number: 46340

Part Number: D32721

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC21	FINAL INSPECTION/W/O RELEASE

09/04/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

mf
09-03-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3272 REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS

REV	DATE	DESCRIPTION
A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

DART

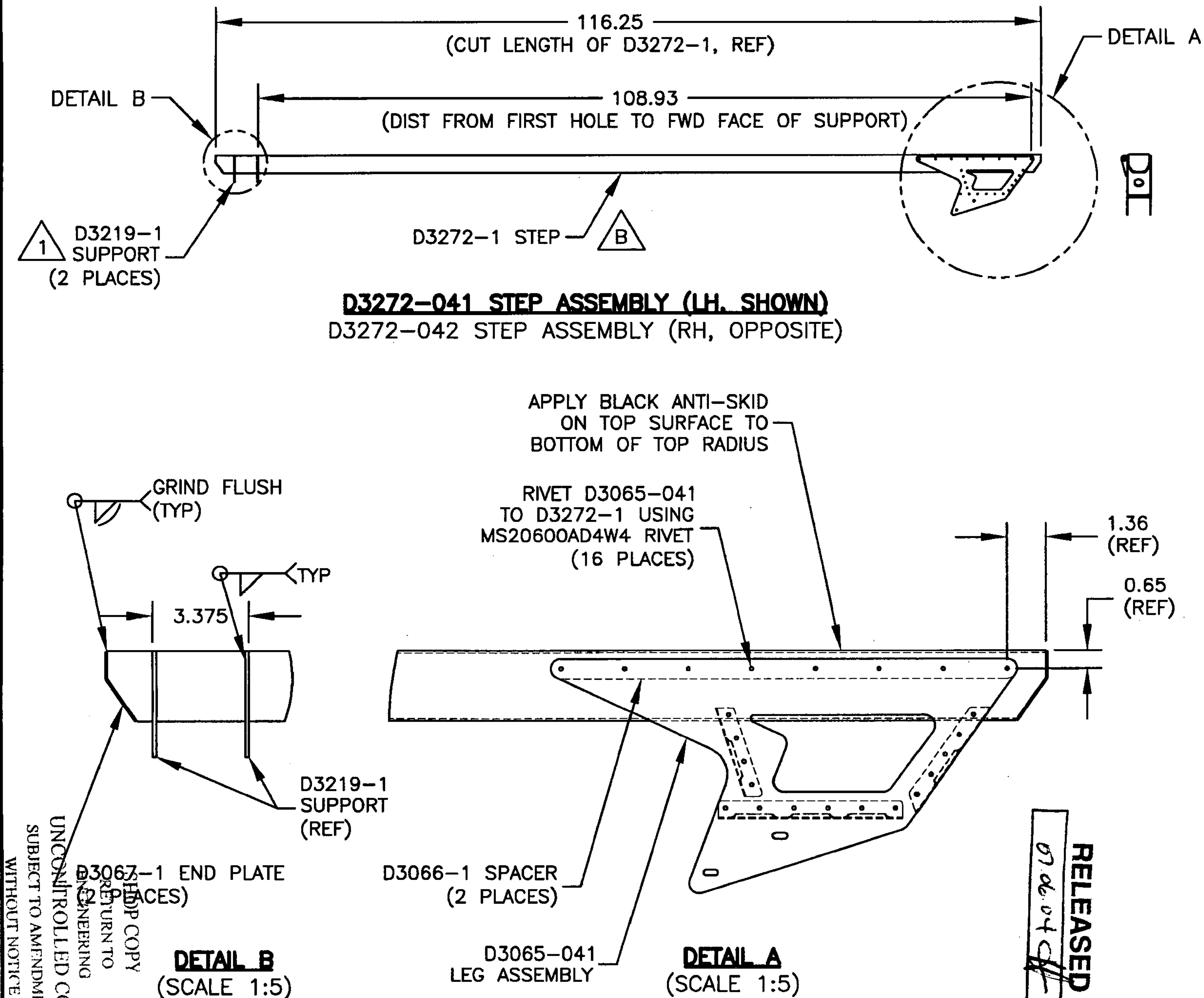
RELEASED 07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1 (B)	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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NO. 46340



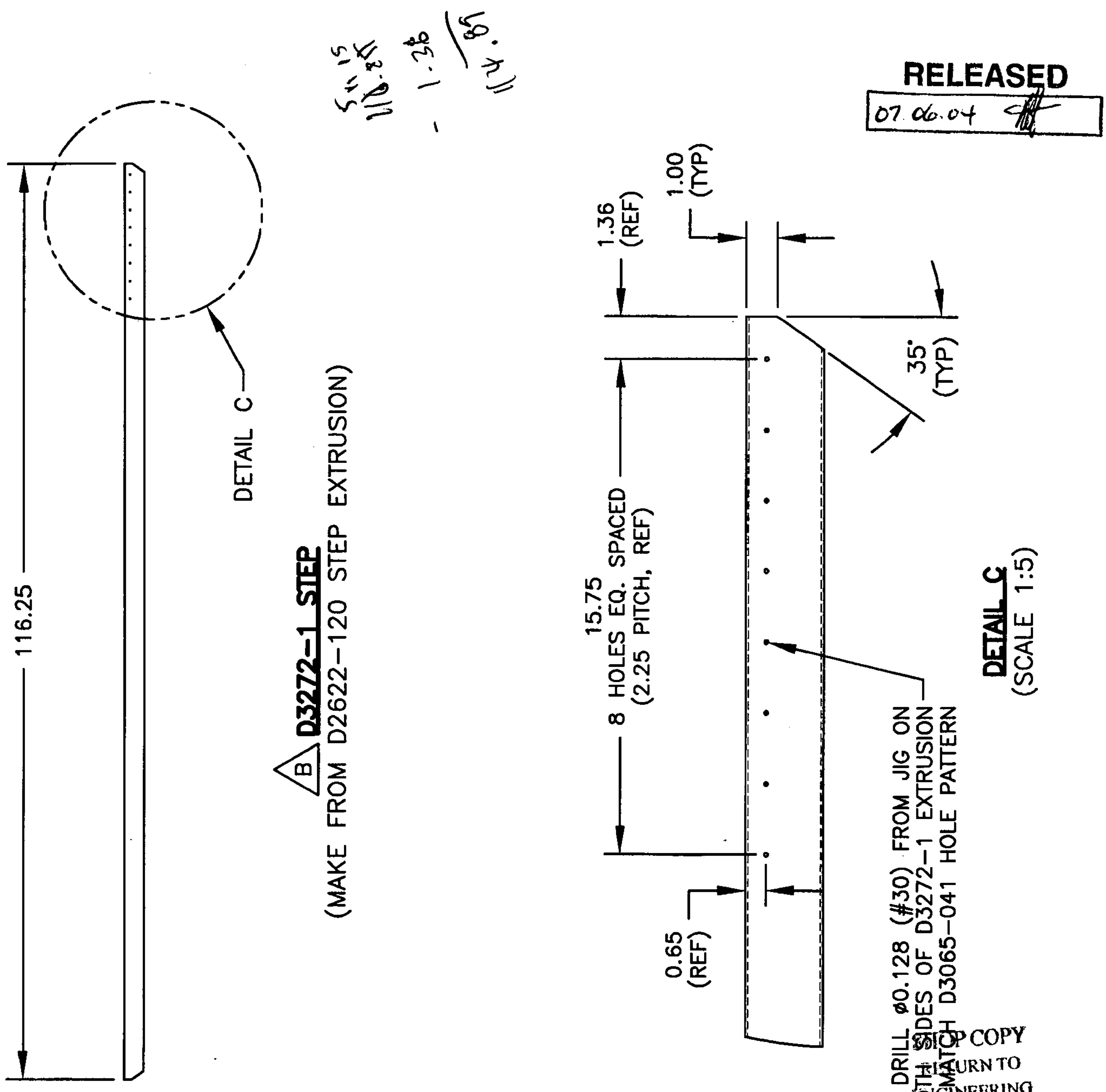
DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 2 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



RELEASED
07.06.04

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